



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.4001
Job Sheet 208673



Part No: 646.4001

Job Qty: 1 pcs

Part Name: AS350 Cable Cutter System



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/30/20

Job Tracking No:

Due Date: 4/30/20

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG REV C1 IPP REV:A 12.10.23 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.08 AS PER DWG REV.B DD VERF:JLM IPP REV:C 16.01.07 AS PER DWG REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1 pcs	4/30/20		0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
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							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22	DAS	
							Packaging 1 - 23	34	
							Packaging 1 - 24	9-89	
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com



Container No: S274246

Part: 646.4001

Job No: 208673

Serial No/Batch: S274246

Revision:

Inspector:

Exp Date:

Instructions: FAA STC SR02180LA 14/08/07 04216 STC SH09 -

Plex 3/30/20 10:55 AM Dart.lajeunesse.marie

FG102

120	QC 4	1 pcs	4/30/20	0.00 0.00	Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
					Packaging 1 - 37	
					QC 4 - 28	
					QC 4 - 58	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	
					QC 4 - 68	
					QC 4 - 72	DAS 72
					QC 4 - 74	9-89
130	Packaging 3-1 - Stock - B4B	1 pcs	4/30/20	0.00 0.00	QC 4 - 75	
					QC 4 - 78	
					QC 4 - 84	
					QC 4 - 80	
					QC 4 - 85	
					Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	DAS
					Packaging 3 - 24 - B4B	72
					Packaging 3 - 25 - B4B	9-89
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
135	DC - 1 - B4B	1 pcs	4/30/20	0.00 0.00	DC - 1 - B4B	DAS
					DC - 2 - B4B	21

140 QC 21 - FG

1 pcs

4/30/20

0.00 0.00

QC 21 - FG - 21

DAS

QC 21 - FG - 70

21

QC 21 - FG - 53

9-88

MAY 01 2020

Part Op 110 - pick kit

Descriptions: 120 - QC4- 100% Inspect kits for completeness

130 - Identify and pack for shipping as per PPP 646.4001 Location: _____

135 - Document Control - Photocopy bluefile & type labels per PPP 646.4001

140 - QC21- Final Inspection - Work Order Release

015590

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
600.0129	VHB Tape	8 ft (8 ea)	110-Packaging 1 - Pick Kit	5215203
600.0990	Magnabond 6398 Part A Size 112 ml	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5248655
600.0991	Magnabond 6398 Part B Size 112 ml	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5248659
600.1012	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5266898
600.1013	021200-3M Tape Primer 94 Primer 24216	5 Ea (5 ea)	110-Packaging 1 - Pick Kit	5221172
646.2910	Deflector	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5243804
646.3001	Lower Cable Cutter Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5260179
646.3110	Channel	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5233062
646.3210	Support	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5221454
646.3301	Upper Cutter Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5235306
646.3510	Strut	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5218952
646.3511	Strut	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5218965
646.3610	Filler	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5230345
646.3710	Doubler	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5249289
646.3711	Clip	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5218358
646.3712	Clip	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5219276
646.3713	Gusset	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5219291
646.3714	Gusset	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5219319
646.3715	Strut Doubler	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5252845
646.3716	Gauge Bracket	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5233890
646.3717	Doubler	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5235110
646.3718	Custom Washer	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5219261
646.3719	Doubler	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5218795
646.3810	Bracket	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5253466
646.3811	Radius Block	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5229075
646.3812	Gusset Bracket	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5236995
646.3813	AS350 Strut Bracket	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5234869
646.3910	Shim	4 pcs (4 ea)	110-Packaging 1 - Pick Kit	5236294 + 5270673x3
646.3911	Shim	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5220038
646.3912	Shim	4 pcs (4 ea)	110-Packaging 1 - Pick Kit	5218106 + 5270679x3
646.3913	Shim	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5218110
646.9410	Shim	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5056998
647.0112	Strut Bracket	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5258631
647.7703	Strut Assembly	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5258162
650.9201	Eyelet Bracket Assembly	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5229706
AN3-11A	Bolt	10 Ea (10 ea)	110-Packaging 1 - Pick Kit	5228829
AN3-12A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5166926
AN3-13A	Bolt	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5228738
AN3-3A	Bolt	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5253401
AN3-4A	Bolt	10 Ea (10 ea)	110-Packaging 1 - Pick Kit	5253438
AN3-5A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5255501
AN3-6A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5194395
AN316C4R	Nut, Jam	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5237320
AN44-5A	Eyebolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5216330
AN4C7A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5251071
AN665-34R	Clevis	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5239635
CCR264SS3-02	Cherry Rivet	36 Ea (36 ea)	110-Packaging 1 - Pick Kit	5255696
CR3213-5-3	Cherry Rivet	14 Ea (14 ea)	110-Packaging 1 - Pick Kit	5231389
MS20426AD5-7	Rivet	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	51133922
MS20470AD5-5-5	Rivet	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5155876
MS20470AD5-6	Rivet	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5048897

MS20470AD5-7	Rivet	3 Ea (3 ea)	110-Packaging 1 - Pick Kit	5263251
MS21042L08	Nut	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5250462
MS21042L3	Nut	63 Ea (63 ea)	110-Packaging 1 - Pick Kit	5250762
MS21042L4	Nut	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5260063
MS21047-3	Nut Plate	18 Ea (18 ea)	110-Packaging 1 - Pick Kit	5265315
MS24693-C278	Screw	5 Ea (5 ea)	110-Packaging 1 - Pick Kit	5257794
MS24694-S51	Screw	5 Ea (5 ea)	110-Packaging 1 - Pick Kit	5235148
MS24694-S54	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5145069
MS24694-S55	Screw	3 Ea (3 ea)	110-Packaging 1 - Pick Kit	5268679
MS27039-08-13	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5247725
MS27039-1-10	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5247871
MS27039-1-12	Screw	6 Ea (6 ea)	110-Packaging 1 - Pick Kit	5259044
MS27039-1-16	Screw	24 Ea (24 ea)	110-Packaging 1 - Pick Kit	5231298
MS27039-1-19	Screw	22 Ea (22 ea)	110-Packaging 1 - Pick Kit	524063x12
MS27039-1-20	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5235395
MS27039-1-21	Screw	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5243417
NAS1149F0332P	Washer (AN960-10L)	144 Ea (144 ea)	110-Packaging 1 - Pick Kit	522x014
NAS1149F0363P	Washer (AN960-10)	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5171793
NAS1149F0432P	Washer (AN960-416L)	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5264512
NAS1149FN832P	Washer (AN960-8)	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5275330
				5259479
				5248080

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	600.0129	8	282	0
	600.0990	1	42	0
	600.0991	1	45	0
	600.1012	1	38	0
	600.1013	5	130	0
	646.2910	1	11	0
	646.3001	1	12	0
	646.3110	1	14	0
	646.3210	1	10	0
	646.3301	1	10	0
	646.3510	1	19	0
	646.3511	1	17	0
	646.3610	1	32	0
	646.3710	1	30	0
	646.3711	1	12	0
	646.3712	1	18	0
	646.3713	1	17	0
	646.3714	1	18	0
	646.3715	2	43	0
	646.3716	1	33	0
	646.3717	1	19	0
	646.3718	2	23	0
	646.3719	2	8	0
	646.3810	2	43	0
	646.3811	1	26	0
	646.3812	2	44	0
	646.3813	1	25	0
	646.3910	4	5	0
	646.3911	1	34	0
	646.3912	4	7	0
	646.3913	1	11	0
	646.9410	1	29	0
	647.0112	2	182	0
	647.7703	2	24	0
	650.9201	2	21	0
	AN3-11A	10	263	0
	AN3-12A	2	118	0
	AN3-13A	1	48	0
	AN3-3A	4	290	0
	AN3-4A	10	390	0
	AN3-5A	2	248	0
	AN3-6A	2	199	0
	AN316C4R	2	98	0
	AN44-5A	2	36	0
	AN4C7A	2	250	0

AN665-34R	2	107	0
CCR264SS3-02	36	604	0
CR3213-5-3	14	477	0
MS20426AD5-7	2	447	0
MS20470AD5-5-5	8	609	0
MS20470AD5-6	8	401	0
MS20470AD5-7	3	963	0
MS21042L08	2	1,318	0
MS21042L3	63	1,848	0
MS21042L4	2	2,713	0
MS21047-3	18	432	0
MS24693-C278	5	91	0
MS24694-S51	5	169	0
MS24694-S54	2	115	0
MS24694-S55	3	320	0
MS27039-08-13	2	205	0
MS27039-1-10	2	266	0
MS27039-1-12	6	177	0
MS27039-1-16	24	464	0
MS27039-1-19	22	632	0
MS27039-1-20	2	93	0
MS27039-1-21	4	131	0
NAS1149F0332P	144	3,855	0
NAS1149F0363P	2	667	0
NAS1149F0432P	4	1,456	0
NAS1149FN832P	4	3,373	0

Part Specifications

Specifications could not be found.

Plex 3/30/20 10:55 AM Dart.lajeunesse.marie

Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐		DEPARTMENT/PROCESS Cross tube ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ Small Fab ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ Finishing ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ Skid-tube ☐ ☐ ☐ Machining ☐ ☐ ☐ Large Fab ☐ ☐ ☐		Engineering ☐ ☐ ☐ Water Jet ☐ ☐ ☐ Supplier ☐ ☐ ☐ Quality ☐ ☐ ☐																																																																									
Date: _____		Sequence #: _____		QTY Affected: _____		MRB (QSI042)																																																																									
Description Work Order Deviation				Disposition																																																																											
Root Cause <table border="1"> <tr> <td>Operator</td><td>☐</td> </tr> <tr> <td>Manufacturing Process</td><td>☐</td> </tr> <tr> <td>Equip/Tooling</td><td>☐</td> </tr> <tr> <td>Handling/Preservation</td><td>☐</td> </tr> <tr> <td>Material</td><td>☐</td> </tr> <tr> <td>Product Improvement</td><td>☐</td> </tr> <tr> <td>Process Improvement</td><td>☐</td> </tr> <tr> <td>Human Factors</td><td>☐</td> </tr> </table>				Operator	☐	Manufacturing Process	☐	Equip/Tooling	☐	Handling/Preservation	☐	Material	☐	Product Improvement	☐	Process Improvement	☐	Human Factors	☐	FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td><td>☐</td> <td>Contamination</td><td>☐</td> <td>Power Loss/Surge</td><td>☐</td> <td>Positioned Wrong</td><td>☐</td> </tr> <tr> <td>Bending</td><td>☐</td> <td>Misaligned/off center</td><td>☐</td> <td>Folio/Program</td><td>☐</td> <td>Outside Tolerance</td><td>☐</td> </tr> <tr> <td>Crushing</td><td>☐</td> <td>BOM/Route</td><td>☐</td> <td>Grain Direction</td><td>☐</td> <td>Drawing</td><td>☐</td> </tr> <tr> <td>Cracks</td><td>☐</td> <td>Broken/Damage/Defect</td><td>☐</td> <td>Weld</td><td>☐</td> <td>Finish</td><td>☐</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td><td>☐</td> <td>Incomplete/Unclear Instructions</td><td>☐</td> <td>Wrong Stock Pulled</td><td>☐</td> <td>Part Lost/Missing</td><td>☐</td> </tr> <tr> <td>Marks/Chatter</td><td>☐</td> <td>Drill Holes</td><td>☐</td> <td>Out of Sequence</td><td>☐</td> <td>Misread</td><td>☐</td> </tr> <tr> <td>Mislabeled</td><td>☐</td> <td>Fit/Function</td><td>☐</td> <td>Off-set/Set-up</td><td>☐</td> <td></td><td></td> </tr> </table>				Pressure/Forced	☐	Contamination	☐	Power Loss/Surge	☐	Positioned Wrong	☐	Bending	☐	Misaligned/off center	☐	Folio/Program	☐	Outside Tolerance	☐	Crushing	☐	BOM/Route	☐	Grain Direction	☐	Drawing	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Finish	☐	Crimp/Kink/Ripple/Wave/Twist	☐	Incomplete/Unclear Instructions	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Marks/Chatter	☐	Drill Holes	☐	Out of Sequence	☐	Misread	☐	Mislabeled	☐	Fit/Function	☐	Off-set/Set-up	☐		
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Other/Details: _____																																																																															
Completed By				Lead hand / Supervisor																																																																											
QC / QA Coordinator																																																																															

REQUIRE DIFFERENT LENGTH SCREWS. USE F/N 62 TO REPLACE F/N 44 & F/N 26 IN PLACE OF F/N 41 WHEN NECESSARY.

05304

[illegible]

REV	DESCRIPTION	SHEET	DATE
1	REVISIONS		
2	REVISIONS		
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100	REVISIONS		

SCALE: NONE
SHEET 1 OF 5

AS350 CABLE CUTTERS KIT
B DWA6 646.4000
C

DART 3030 ENTERPRISE CT.
SUITE A
AIRSPACE VISA CA 92081
TEL: 619/744-5500
FAX: 619/744-5500